Work Order ID 79401
January-25-12 1:23:23 PM

Ship JAN 31

79401

Item ID: D3436-044
Revision ID:
Item Name: Step RH

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 25/01/2012 **Start Qty:** 2.00 *2*
Required Date: 31/01/2012 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** M.C.J **Date:** 12/01/25 **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run **Start** *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3436	Rev A

100 — 0.00

100
Large Fab — Large Fab
Large Fab

AL 12-1-30 (x2)

Memo 0.00

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436Dwg Rev: A

Qty	Part Number	Description	Batch
A/RN/A		4130 Welding Rod	M9326

Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436Dwg Rev: A

Qty	Part Number	Description	Batch
A/RN/A		4130 Welding Rod	M9326

Weld cap D3436-7 as per Dwg D3436Dwg Rev: A

Qty	Part Number	Description	Batch
A/RN/A		4130 Welding Rod	M9326

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 79401 *79401*

January-25-12 1:23:23 PM

Item ID: D3436-044 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Step RH

Start Date: 25/01/2012 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 31/01/2012 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Bandsaw Jeaspa Bandsaw	BAND SAW **Memo** 1-Slit part D3436-041 on bandsaw as per Dwg D3436 2- deburr	0.00 0.00				AL	12-1-30		(x2)
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds **Memo**	0.00 0.00				2	Ø	BE 12-01-30	
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 SP 12/01/30				(x2) RY			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79401

January-25-12 1:23:23 PM

79401

Item ID: D3436-044 **Accept** *N900040100* **Setup** **Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Step RH

Start Date: 25/01/2012 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 31/01/2012 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Run **Start** *NR1* **Stop** *NR2*

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Powdercoat Powder Coating M119480	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel **Memo** START TIME: 1:00 OVEN TEMPERATURE: 400°F FINISH TIME: 1:30 ***Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4*** 130/135	0.00 0.00				2X0 M 12/01/30 2 12-1-31.			
150 *150* QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				2xRH 12/1 counted + identified			
155 *155* Small Fab Small Fab	**Memo** Bond pads per dwg and QSI 015	0.00 0.00				12/01/31 (2)			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 79401
January-25-12 1:23:23 PM

79401

Item ID: D3436-044
Revision ID:
Item Name: Step RH

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 25/01/2012 **Start Qty:** 2.00 *2*
Required Date: 31/01/2012 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Run **Start** *NR1*
Stop *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 5 Jan/31				(2) RH			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location:_______ **Memo**	0.00 0.00				12/1/31			
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00					12/2/1		

MF
12-01-31

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-25-12 1:23:27 PM

Work Order ID: 79401 *79401*

Parent Item: D3436-044 *D3436-044*

Parent Item Name: Step RH

Start Date: 25/01/2012 **Required Date:** 31/01/2012

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP A 05.05.11New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3436-5 *D3436-5* Bushing		Manufactured	No			100	Each	40.0000	4 **	8			
				Location		Loc Qty	Loc Code						
				ST044		20							
				46592		20							
				WA024		20							
				75229		20							
D3436-7 *D3436-7* Cap		Manufactured	No			100	Each	39.0000	1 **	2			
				Location		Loc Qty	Loc Code						
				WA021		39							
				56836		39							
D3436-9 *D3436-9* Pad		Manufactured	No			100	Each	0.0000	2 **	4			
D3436-4 *D3436-4* Right Step		Manufactured	No			100	Each	5.0000	1 **	2			
				Location		Loc Qty	Loc Code						
				WA022		5							
				73545		5							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ________________ **Disposition:** ________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-25-12 1:23:27 PM

Work Order ID: 79401 *79401*

Parent Item: D3436-044 *D3436-044*

Parent Item Name: Step RH

Start Date: 25/01/2012 **Required Date:** 31/01/2012

Start Qty: 2.00 **Required Qty:** 2.00

D3436-1	Manufactured	No	155	Each	37.0000	1	2

D3436-1

Clamp

** 12 12-30

Location	Loc Qty	Loc Code	
WA024	37		
17679	37		2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

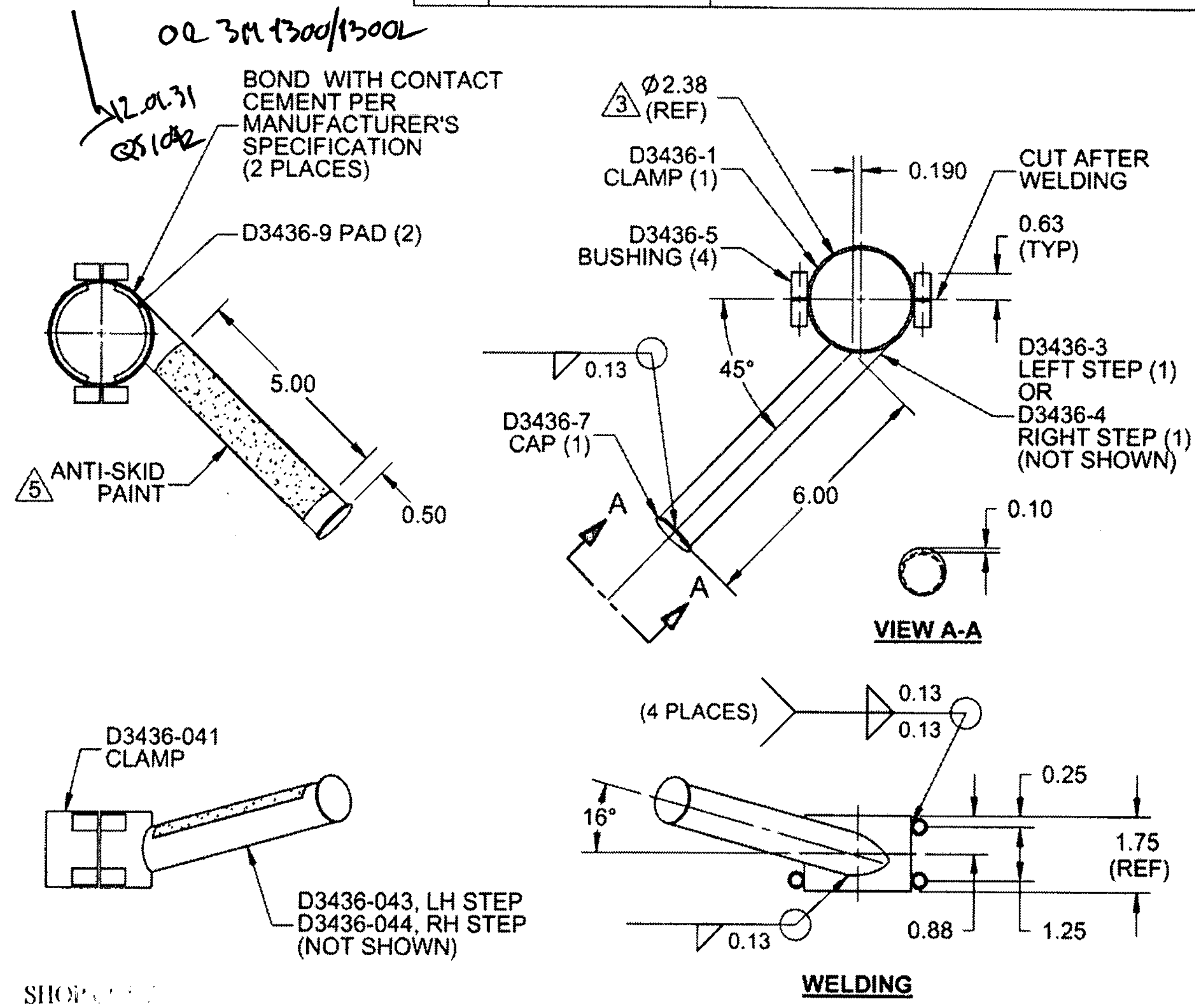
Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DESIGN	DRAWN BY	**DART AEROSPACE LTD**
MB	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3436 — REV. A — SHEET 1 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP — SCALE 1:4
A	05.04.28	NEW ISSUE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 79401
M.L.J
12/01/25

RELEASED
05.05.27

NOTES:

1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
2) WELD PER DART QSI 004
3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7) ALL DIMENSIONS ARE IN INCHES

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

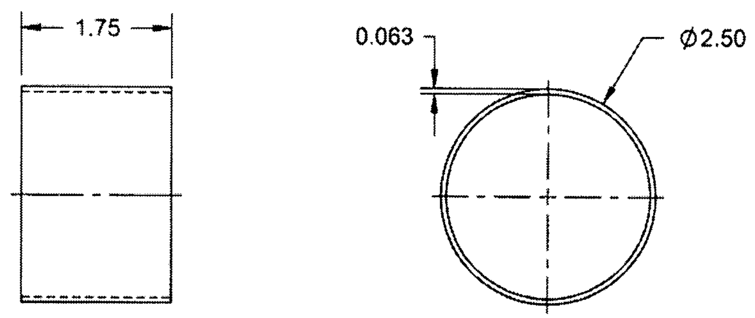
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79401

DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3436 — REV. A — SHEET 2 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP — SCALE 1:2



D3436-1 CLAMP

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED
05-05-27

D3436-1/ -5, GENERAL NOTES:

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ PAR #: ______ Fault Category: ______________ NCR: Yes No DQA: _____ Date: _________

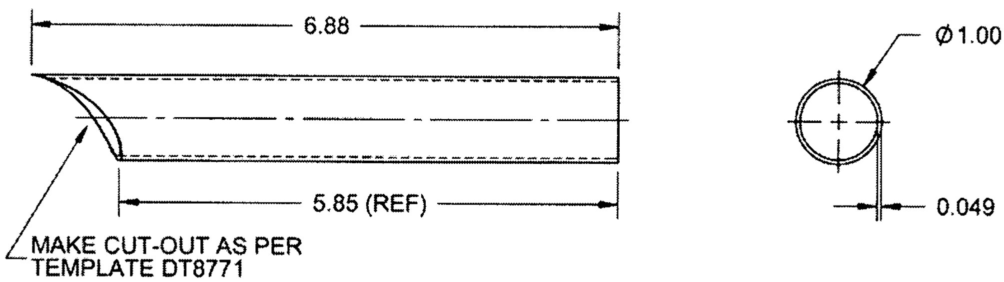
Resolution: ________________ Disposition: ________________ QA: N/C Closed: _________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

79401

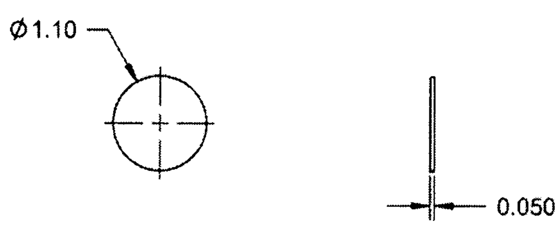
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED
05-05-27

D3436-3/ -7, GENERAL NOTES:

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

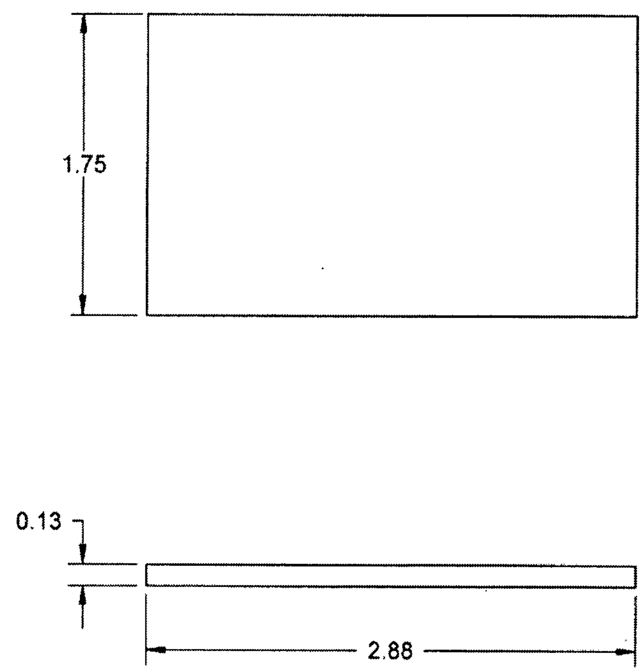
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

79401

DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE	05.04.28	TITLE MAINTENANCE STEP	SCALE 1:1



RELEASED
05.05.27

D3436-9 PAD

NOTES:

1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries